

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000139**Date Inspected:** 29-May-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Song Wei Min**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Welder Qualification Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to welding, testing and fabrication procedures at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

At 1400 hours ZPMC Quality Assurance (QA) Inspector observed ZPMC perform welder qualification tests at the ZPMC test center. Also present to witness the testing was ZPMC QA Inspector, Mr. Lu Jian Hua, American Bridge/Fluor (ABF) Quality Control (QC) subcontractor, Bureau Veritas (BV) inspector, Mr. Song Wei min and Moody International(s) Certified Welding Inspector (CWI), Mr. Zhou Da Qing. Caltrans QA observed welders performing shielded metal arc welding (SMAW 3G), flux core arc welding (FCAW 3G) and submerged arc welding (SAW 1G) welder and welder operator qualification testing. Caltrans QA observed BV QC inspector, Mr. Song and Moody International(s) certified welding inspector, Mr. Zhou monitoring and supervising the testing, per posted welding procedure criteria for; amperages, voltages, travel speeds, preheat and interpass temperatures. Caltrans QA observed welders not wire brushing between weld passes, nor chipping slag prior to the resuming a weld pass after the changing out of an electrode and welding weld passes with a non-continuous welding arc. Caltrans QA informed Bureau Veritas QC inspector, Mr. Song of inspection results. Mr. Song had no comment. The identified FCAW, SMAW and SAW welder/operator qualification test plates as follows:

FCAW: #070409100, 070409102, 070409103, 070409104, 070409105, 070409106, 070409107, 070409108, 070409109, 070409110, 070409111, 070409112, 070409113, 070409114 and 070409115.

SMAW: #070409051, 070409052, 070409053, 070409054, 070409055, 070409056, 070409057, 070409058 and 070409059.

SAW: #070409001, 070409002, 070409003 and 070409004.

Moody International inspector, Mr. Zhou Da Qing reported that the evaluation of the test plates would not be

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completed by Moody, until all welder qualification tests has been completed. Mr. Zhou also states, that that remainder of the welder qualification test would be performed the following day, April 30, 2007.



Summary of Conversations:

As identified within the contents of this report. See Task Leader journal for additional information this week.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
